



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-675-015
Job Sheet 172344



Part No: D119-675-015

Job Qty: 1 ea

Part Name: Dart Crosstube Compatibility Installation



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/15/18

Job Tracking No:

Due Date: 2/21/18

Created By: Linda Lacelle

Type: Return

Description:

Note: DWG REV C IPP REV:A 15.11.09 NEW ISSUE DD VERF:JLM

Ship Via:

RA194

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/21/18	0.00	0.00	Start Up Stores/Pkg-1		
120	QC	1 pcs		2/21/18	0.00	0.00	QC4		SMB
125	DC	1 pcs		2/21/18	0.00	0.00	DC		
130	Packaging	1 pcs		2/21/18	0.00	0.00	Packaging3-1		SMB
140	QC21-FG	1 Ea		2/21/18	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile & type labels per PPPD119-675-015 CHG001
Descriptions: 130 - Package as per PPPD119-675-015

DAS
21 MAR 05 2018
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-675-015	Dart Crosstube Compatibility Installation	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-675-015	1	1	0

Part Specifications

Specifications could not be found.

Plex 2/15/18 1:29 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Part Number

D119-796-101

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S042684



Part: D119-675-015

Serial No/Batch: S042684

Revision: IIN - D119-675

Inspector:

Date: 02/15/18 13:32 PM

Customer QA Ref #

0

Work order

S038449

Work order instructions

D119-796-101 was originally ship without paint (only on primer).
Crosstube will need to be disassemble and rework to drawing as followed:
D119-796-151

- Remove and scrap clamps MS21920-22 and cushion D5123-3.
- Remove and keep step assembly D5149-041. D119-796-141
- Remove and scrap clamps MS21920-24.
- Proceed as instructed on BOM from sequence 246.

Assemble D119-796-151 using original step assembly D5149-041.
Repackage with rest of original kit.
Stock with new batch number at CHG 004.
Add new labels and paper work.

D119-675-015

S031459

#VALUE!

☐ Yes☐ Yes☐ Yes☐ Yes

STOCK

S038450

Kit complete with no damage and not open by customer.
Still in original package.
Stock with new batch number at CHG 001.
Add new labels and paper work.

0

#VALUE!

☐ Yes☐ Yes☐ Yes☐ Yes

0

#VALUE!

☐ Yes☐ Yes☐ Yes☐ Yes

0

#VALUE!

☐ Yes☐ Yes☐ Yes☐ Yes

0

#VALUE!

☐ Yes☐ Yes☐ Yes☐ Yes

QC Approval: P.D.

Date: 3-Feb-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

5.2 Maintenance Step and Compatibility Kits Parts List

ITEM	Qty -013	Qty -015	Part Number	Description
	X		D119-675-013	MAINTENANCE STEP
		X	D119-675-015	DART CROSSTUBE COMPATIBILITY KIT
100	2		D4084-1	MAINTENANCE STEP
101	4		AN5-7A	BOLT
102	4		AN5-11A	BOLT
103	8		NAS1149D0563J	WASHER (OR AN960JD516)
104		8	D2732-032	RUBBER CUSHION
105		2	D5283-7	CLAMP
106		2	D5283-11	CLAMP
107		2	D5283-041	CLAMP
108		2	D5283-043	CLAMP
109		4	AN4-15A	BOLT
110		4	AN4-16A	BOLT
111		4	AN4-22A	BOLT
112		24	NAS1149D0463J	WASHER (OR AN960JD416)
113		12	MS21042L4	NUT (OR MS21042-4)